

Date: Thursday, 16/08/2007 3:10:11 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206L AFT X-TUBE
<b>Job Number</b> : 34040	
<b>Estimate Number</b> : 10973	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206667203 <i>BL</i>
<b>This Issue</b> : 16/08/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D206-667-243 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 16/08/2007 <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 33689	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 05/09/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : Est Rev: F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM	

*BLUB*

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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*KJ 07.08.07* ①**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

*E 02/09/11*

2.0	D6004115	Crosstube material
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube *B29114*

Check OD = 2.500"; ID = 1.800"

*2.8 07/09/17* ①

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

*2.8 07/09/17* ①

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------

**Comment:** INSPECT ALL DIM TO DIM SHEET*2.8 07/09/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34040

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243  
Inside of Cuff(Donot engrave on outside of tube)

28 07/08/17

6.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

28 07/08/17

7.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

28 07/08/17

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

DP

7-9-4

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

28 07/08/17

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7-9-4

W/O:		WORK ORDER CHANGES					
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## Process Sheet

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Drawing Name: 206L AFT X-TUBE

Job Number: 34040

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT EL 7-9-4

12.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

07-09-04 (P)

13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

(PTO)

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243  
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

(PTO)

ET  
07-09-05

Job 7-9-6

14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Job 7-9-6  
~~Job 7-9-4~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/19/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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070904	13.1	Tube is 0.1075" too low on the height + dimensions	<i>[Signature]</i> 05/04/12	Tube is within Q.C. tolerance. Drill cuffs at 0680 to compensate on the height.	<i>[Signature]</i> 07/09/07	<i>[Signature]</i> 07/09/07	<i>[Signature]</i> 05/04/12	<i>[Signature]</i> 070904

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Job Number: 34040

Part Number: D206667203 *BL*

Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*En 01/09/06*

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*CA checked all holes*

*En 01/09/06*

17.0 OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: *4530*

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*ll*

*07-09-06*

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*CD 07/09/07 ①*

19.0 QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

*07-09-07 ①*

20.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Iron as per QSI 005 4.2

*07-09-07*  
*CD 07/09/07 ①*  
*Atelier*  
*Delussel 200*  
*Issue P.O. 4543*  
*spray paint DelShot Blue & clear*

21.0 QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

*07-09-10*

*206.*

*Receive + Inspect for transit damage*

*07/09/07*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 34040

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	D2873045	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

32777

KT 07.09-08

23.0	D2873043	Nut Plate Assembly
------	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

29286

KT 07-09-08

24.0	MS20601AD4W10	RIVET
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Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

105057

KT 07-09-08

25.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

KT 07-09-08

26.0	D2856400	Abrasion Strip
------	----------	----------------



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73")

Abrasion Strip

32992

KT 07-09-10

27.0	D28921	Support
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

34148

KT 07-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 34040

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation: Description :

28.0 MS2192022 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

101722

ET-07-09-10

29.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ET-07-09-10

30.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

31.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0 AN534A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M102850

33.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M104547

CP

B

ET-07-09-10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/02/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 34040

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M105144

35.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M102850

36.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M104156

37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

39.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07-09-11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.07.26 #

**UNDER REVIEW**  
06.08.10 RH  
re-draw detail F

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

w/o 34040

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W/O:		WORK ORDER CHANGES					
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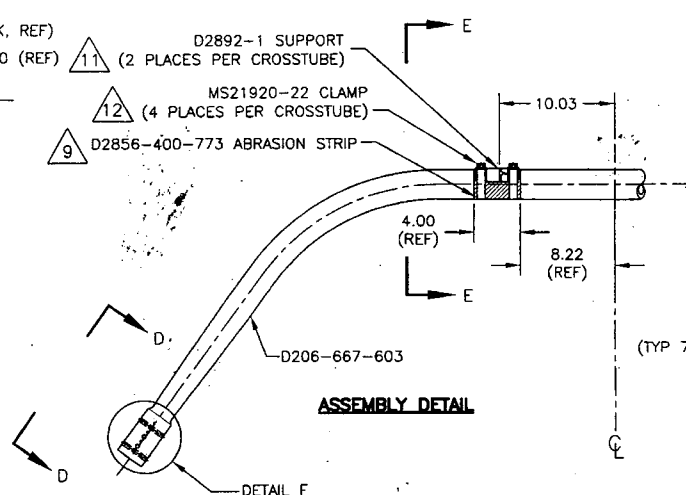
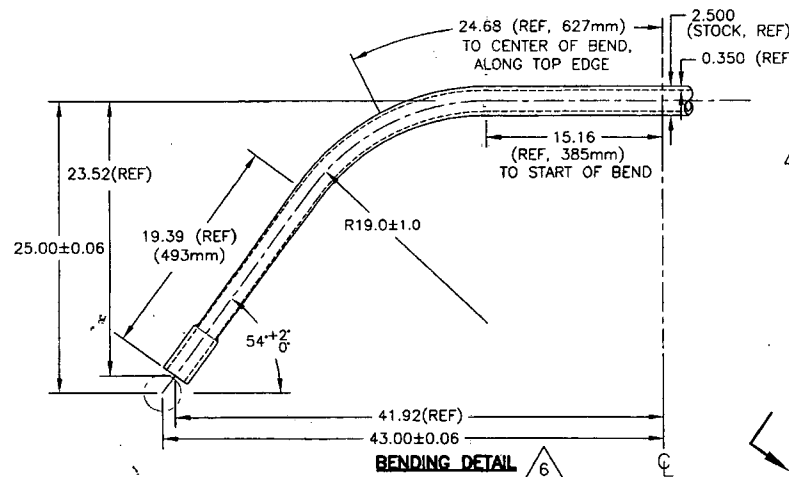
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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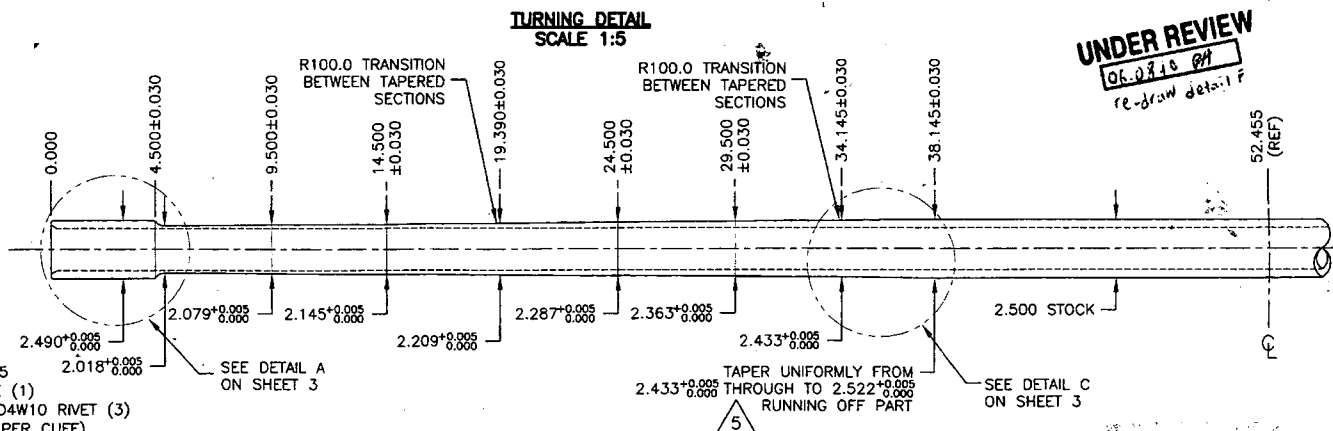
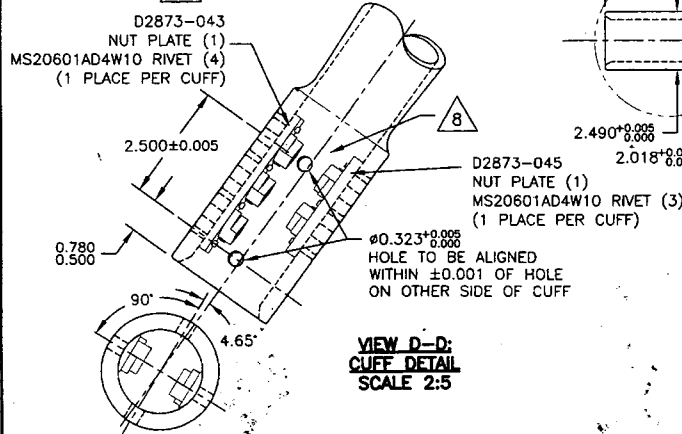
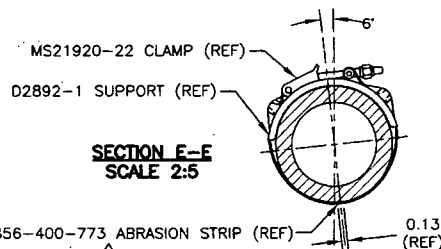
**B**  $\phi 0.323^{+0.005}_{-0.000}$   
(TYP 5 PLACES PER CUFF)  
HOLE TO BE ALIGNED WITHIN  $\pm 0.001$  OF HOLE ON OTHER SIDE OF CUFF

PILOT  $\phi 0.128$   
C'SINK  $\phi 0.225 \times 100'$   
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

**DETAIL E**  
SCALE 2:5

**UNDER REVIEW**  
06.08.18 PH  
re-draw detail F



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
		DATE	05.07.26			D206-667-243	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (206L HIGH AFT)	1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

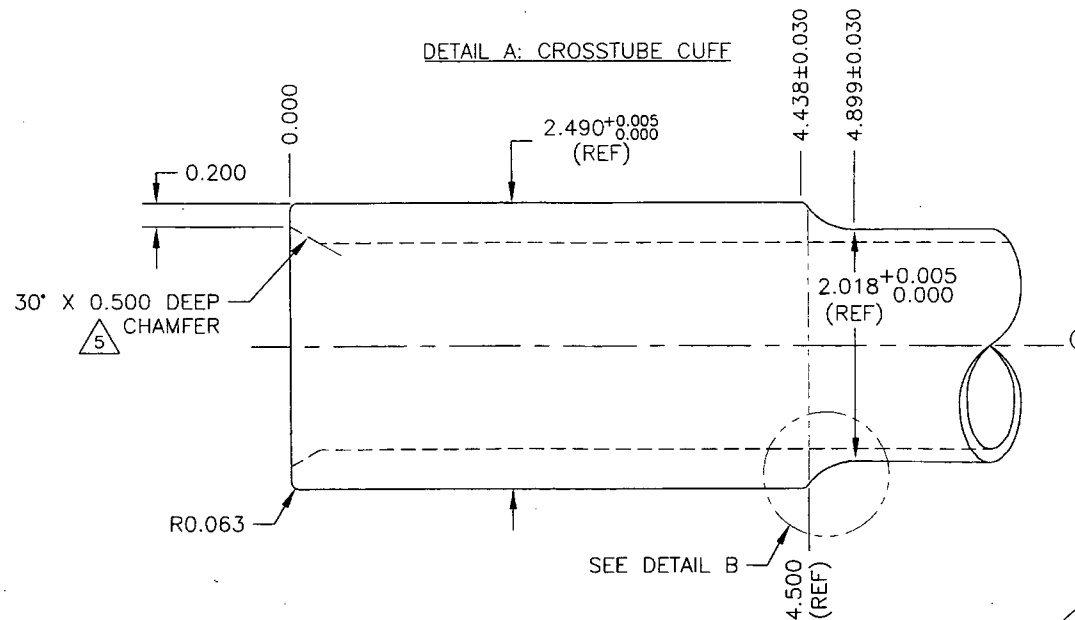
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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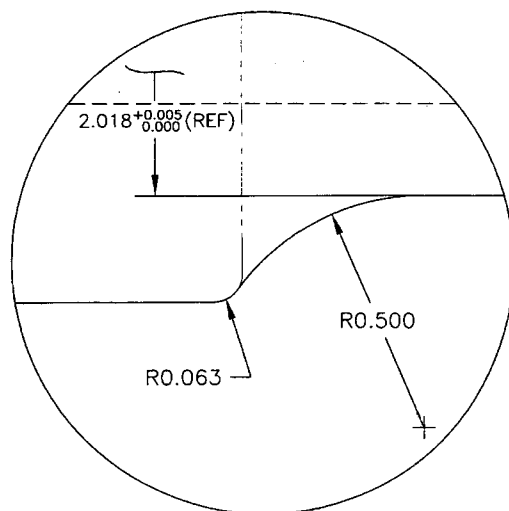
NOTE: Date & initial all entries

# DETAIL A: CROSSTUBE CUFF



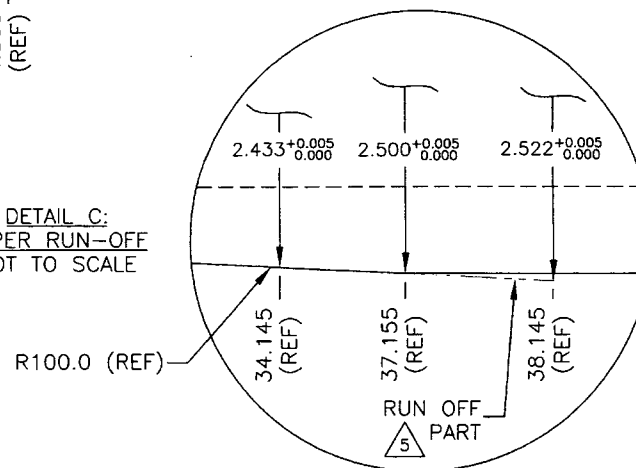
05.07.26 PH

UNDER REVIEW  
06.03.10 PH  
re-draw detail F



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

## DETAIL C: TAPER RUN-OFF NOT TO SCALE



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DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED ADS	APPROVED ADS	DRAWING NO. D206-667-243	REV. B SHEET 3 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

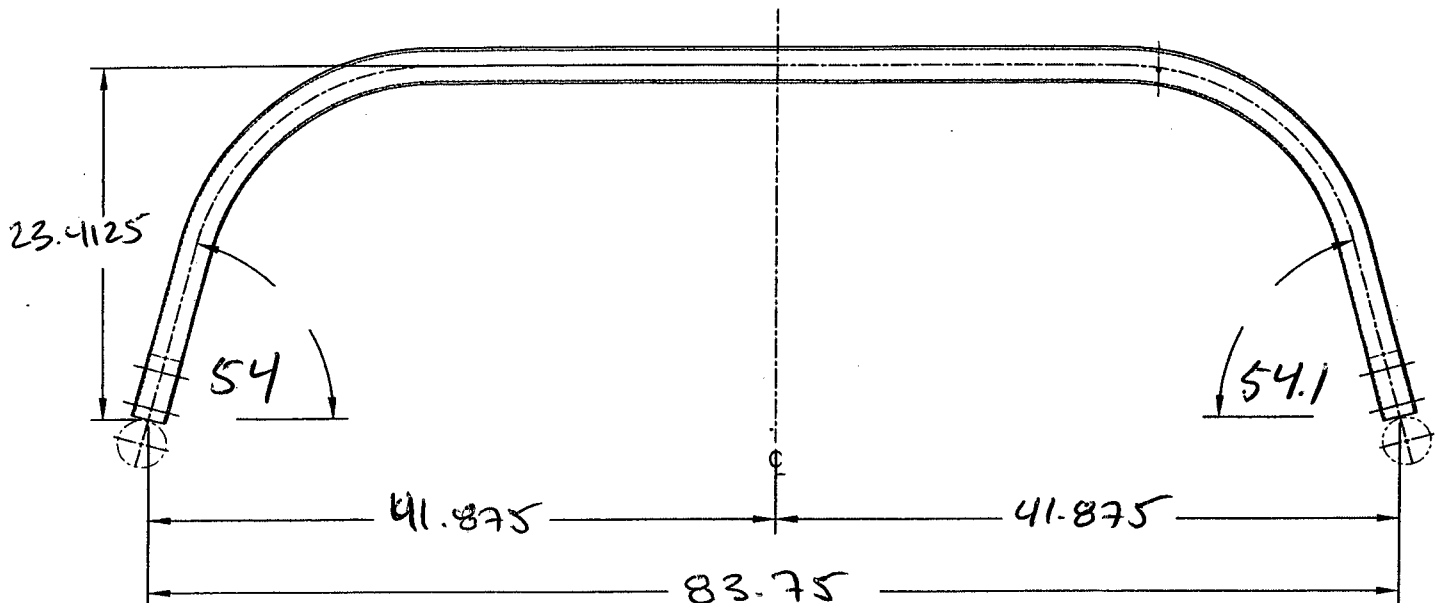
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34040
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
Tube is slightly low on the height. Acceptable.

QC15 Inspection	03/11/12
Date	07.09.04

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 34040
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b> D206-667-243
<b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.493				
	2.018	+0.005/-0.000	2.021				
	2.079	+0.005/-0.000	2.081				
	2.145	+0.005/-0.000	2.148				
	2.209	+0.005/-0.000	2.211				
	2.287	+0.005/-0.000	2.290				
	2.363	+0.005/-0.000	2.366				
	2.433	+0.005/-0.000	2.436				
	0.200	+/-0.010	.202				
	0.500 x 30°	+/-0.010	.500				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.444				
SIDE B	104.91	+/-0.020	104.91				
	2.490	+0.005/-0.000	2.493				
	2.018	+0.005/-0.000	2.021				
	2.079	+0.005/-0.000	2.081				
	2.145	+0.005/-0.000	2.148				
	2.209	+0.005/-0.000	2.211				
	2.287	+0.005/-0.000	2.290				
	2.363	+0.005/-0.000	2.366				
	2.433	+0.005/-0.000	2.436				
	0.200	+/-0.010	.202				
	0.500 x 30°	+/-0.010	.500				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.444				

<b>Measured by:</b> J.B.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/08/17	<b>Date:</b> 07.08.29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37321

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (1) ~~cross tube~~ (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D206-667-203 S/N B34040.

Note: For pick-up 8AM, Friday 07 September 2007.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (1) cross tube.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(1) cross tube inspected. (1) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE September 06, 2007

INSPECTION  
STAMP(S) 

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00004530

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT